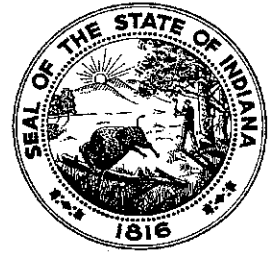


Indiana Department of Labor
Indiana Occupational Safety and Health Administration
402 West Washington Street
Room W195
Indianapolis, IN 46204-2751
Phone: 317/232-1979 Fax: 317/233-8509



certified mail # 7003 1010 0003 5732 3265 6-18-12 jto

Safety Order and Notification of Penalty

To:

Sensient Flavors, LLC,
and its successors
5600 West Raymond Street
Indianapolis, IN 46241

Inspection Number: 315051318

Inspection Date(s): 09/15/2011 - 04/20/2012

Issuance Date: 06/18/2012

Inspection Site:

5600 West Raymond Street
Indianapolis, IN 46241

The violation(s) described in this Safety Order and Notification of Penalty is (are) alleged to have occurred on or about the day(s) the inspection was made unless otherwise indicated within the description given below.

An inspection of your place of employment has revealed conditions which we believe do not comply with the provisions of the Indiana Occupational Safety and Health Act (Indiana Code Chapter 22-8-1.1) or the standards or rules adopted thereunder. Accordingly, enclosed please find safety order(s) and notification(s) of penalty describing such violation(s) with references to applicable standards, rules, or provisions of the statute and stating the amount of any penalty(ies).

Informal Conference - Please be advised that it may be possible to informally settle any potential dispute without initiating the more elaborate proceedings brought on by a petition for review. Prior to filing a petition for review, you may request an informal conference concerning any of the results of the inspection (safety orders, penalties, abatement dates, etc.) by contacting the Indiana Department of Labor/IOSHA, preferably by telephone, in a prompt manner. Please be advised that a request for an informal conference cannot extend the fifteen working day period for filing a petition for review. Informal conferences frequently resolve any possible disputes, and therefore you are urged to take advantage of this opportunity. Because of the limited time period and in order to facilitate scheduling, any requests for an informal conference should be made promptly upon your receipt of the safety order(s) and notification(s) of penalty.

Right to Contest - You are hereby also notified that you are entitled to seek administrative review of the safety order(s), penalty(ies), or both by filing a written petition for review at the above address postmarked within fifteen working days of your receipt of the safety order(s) and notification(s) of penalty. ("Working days" means Mondays through Fridays, but does not include Saturdays, Sundays, legal holidays under a state statute or days

on which the Indiana Department of Labor's offices are closed during regular business hours). If you do not file such a petition for review (contest), the safety order(s) and penalty(ies) shall be deemed final orders of the Board of Safety Review and not subject to review by any court or agency. The issuance of a safety order does not constitute a finding that a violation has occurred unless no petition for review is filed, or if a petition for review (contest) is filed, it must contain a statement of its basis and should reference the above inspection number. Upon receipt of your petition for review, we will affirm, amend or dismiss the safety order(s) and notification(s) of penalty. If we affirm, your petition for review will be granted (unless it was not timely) and the dispute will be certified by the Board of Safety Review for further proceedings. The Board of Safety Review is an independent agency appointed by the governor with authority to conduct hearings and to issue decisions concerning disputed safety order(s) and notification(s) of penalty. If we amend the safety order(s) or notification(s) of penalty, your petition for review shall be deemed moot. However, you will then be given an opportunity to file a petition for review concerning the amended safety order(s) and notification(s) of penalty.

Please be advised that an employee or representative of employees may file a petition for review to contest the reasonableness of the time stated in the safety order(s) for the abatement of any violation.

Posting - Upon receipt of any safety order(s) you are required to post such safety order(s), or a copy thereof, unedited, at or near each place an alleged violation referred to in the safety order(s) occurred. However, if your operations are such that it is not practicable to post the safety order(s) at or near each place of alleged violation, such safety order(s) shall be posted, unedited, in a prominent place where it will be readily observable by all affected employees. For example, if you are engaged in activities which are physically dispersed, the safety order(s) may be posted at the location from which the employees operate to carry out their activities. You must take steps to ensure that the safety order is not altered, defaced, or covered by other material. Posting shall be until the violation is abated, or for three working days, whichever is longer.

Penalties - Penalties are due within fifteen (15) working days of receipt of this notification unless contested. Abatement does not constitute payment of penalties.

Abatement - The conditions cited in the safety order(s) must be corrected (abated) on or before the date shown for each item on the safety order(s) and notification(s) of penalty unless:

- (1) You file a petition for review concerning the violation, in which case the full abatement period shall commence from the issuance of a final decision by the Board of Safety Review or the courts which requires compliance with the safety order; or
- (2) The abatement period is extended by the granting of a petition for modification of abatement date.

PMAs - The petition for modification of abatement date is a manner in which you may seek additional time to correct (abate) a violation without having to file a petition for review concerning the safety order, or after the expiration of the time period to file such a petition for review when it becomes apparent that you need extra time to abate the violation. A petition for modification of abatement date shall be in writing and shall include the following information:

- (1) All steps you have taken, and the dates of such actions, in an effort to achieve compliance during the

prescribed abatement period.

(2) The specific additional abatement time necessary in order to achieve compliance.

(3) The reasons such additional time is necessary, including the unavailability of professional or technical personnel or of materials and equipment, or because necessary construction or alteration of facilities cannot be completed by the original abatement date.

(4) All available interim steps being taken to safeguard employees against the cited hazard during the abatement period.

(5) A certification that a copy of the petition has been posted, and if appropriate, served on the authorized representative of affected employees, and a certification of the date upon which such posting and service was made.

A petition for modification of abatement date shall be filed with the Indiana Department of Labor/IOSHA no later than the close of the next working day following the date on which abatement was originally required. A later-filed petition shall be accompanied by the employer's statement of exceptional circumstances explaining the delay. A copy of such petition shall be posted in a conspicuous place where all affected employees will have notice thereof or near such location where the violation occurred. The petition shall remain posted until the time period for the filing of a petition for review of the Commissioner's granting or denying the petition expires. Where affected employees are represented by an authorized representative, said representative shall be served a copy of such petition.

Notification of Corrective Action - Correction of the alleged violations which have an abatement period of thirty (30) days or less should be reported in writing to us promptly upon correction. A "Letter of Abatement" form and an "Abatement Photographs" worksheet are enclosed for your assistance in providing adequate documentation of abatement. Reports of corrections should show specific corrective action on each alleged violation and the date of such action. On alleged violations with abatement periods of more than thirty (30) days, a written progress report should be submitted, detailing what has been done, what remains to be done, and the time needed to fully abate each such violation. When the alleged violation is fully abated, we should be so advised. Timely correction of an alleged violation does not affect the initial proposed penalty.

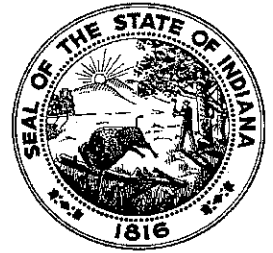
Followup Inspections - Please be advised that a followup inspection may be made for the purpose of ascertaining that you have posted the safety order(s) and corrected the alleged violations. Failure to correct an alleged violation may result in additional penalties for each day that the violation has not been corrected.

Employer Discrimination Unlawful - The law prohibits discrimination by an employer against an employee for filing a complaint or for exercising any rights under this Act. An employee who believes that he/she has been discriminated against may file a complaint no later than 30 days after the discrimination occurred with the Indiana Department of Labor/IOSHA at the address shown above.

Notice to Employees - The law gives an employee or his/her representative the opportunity to object to any abatement date set for a violation if he/she believes the date to be unreasonable. The contest must be mailed to

the Indiana Department of Labor/IOSHA at the address shown above within fifteen (15) working days (excluding weekends and State holidays) or receipt by the employer of this safety order and penalty.

If you wish additional information, you may direct such requests to us at the address or telephone number stated above.



NOTICE TO EMPLOYEES OF INFORMAL CONFERENCE

An informal conference has been scheduled with IOSHA to discuss the safety order(s) issued on 06/18/2012. The conference will be held at the IOSHA office located at 402 West Washington Street, Room W195, Indianapolis, IN 46204 on _____ at _____.

Employees and/or representatives of employees have a right to attend an informal conference.

Indiana Department of Labor

Indiana Occupational Safety and Health
Administration

Inspection Number: 315051318
Inspection Dates: 09/15/2011 - 04/20/2012
Issuance Date: 06/18/2012



Safety Order and Notification of Penalty

Company Name: Sensient Flavors, LLC
Inspection Site: 5600 West Raymond Street, Indianapolis, IN 46241

Safety Order 1 Item 8 Type of Violation: **Serious**

IC 22-8-1.1, Section 2: The employer did not establish and maintain conditions of work which were reasonably safe and healthful for employees, and free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to harmful airborne concentrations of acetic acid which could lead to employees experiencing injuries and/or illnesses such as, but not limited to decreased pulmonary (lung) function and/or severe respiratory tract irritation:

(a) Flammable Liquid Compounding Area - A Compounder was exposed to acetic acid at 28.50 parts per million (ppm) for a 15-minute time-weighted average (TWA); approximately 1.9 times the 2011 American Conference of Governmental Industrial Hygienists (ACGIH) Threshold Limit Value (TLV-STEL) of 15.0 ppm for acetic acid. The exposure level was derived from a 15 minute sampling period on February 2, 2012.

(b) Flammable Liquid Compounding Area - A Compounder was exposed to acetic acid at 54.70 parts per million (ppm) for a 15-minute time-weighted average (TWA); approximately 3.7 times the 2011 American Conference of Governmental Industrial Hygienists (ACGIH) Threshold Limit Value (TLV-STEL) of 15.0 ppm for acetic acid. The exposure level was derived from a 15 minute sampling period on February 2, 2012.

Among other methods, one feasible and acceptable method to correct this hazard is to install a local exhaust ventilation (LEV) system in the portions of the Flammable Liquid Compounding Area where acetic acid is transferred. This LEV system should be sufficient in power (capture velocity, flowrate, etc.) and location so that any acetic acid that is generated and/or emitted during transfer/pouring operations is removed from the point of use or generation prior to entering employees' breathing zones.

Abatement Schedule

STEP 1- Effective respiratory protection shall be provided to and used by exposed employees as an interim measure until feasible engineering and/or administrative controls can be implemented or whenever such controls fail to reduce employee exposure to within permissible exposure limits.

Date By Which STEP 1 Must be Abated

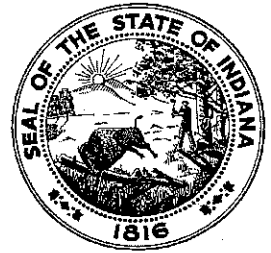
07/06/2012

STEP 2- A written detailed plan of abatement shall be submitted to the Director outlining a schedule for the implementation of engineering and/or administrative measures to control employee exposures to noise as referenced in this Safety Order. This plan shall include, at a minimum, target dates for the following actions which must be consistent with the abatement dates required by this Safety Order:

Indiana Department of Labor

Indiana Occupational Safety and Health
Administration

Inspection Number: 315051318
Inspection Dates: 09/15/2011 - 04/20/2012
Issuance Date: 06/18/2012



Safety Order and Notification of Penalty

Company Name: Sensient Flavors, LLC
Inspection Site: 5600 West Raymond Street, Indianapolis, IN 46241

- (1) Evaluation of engineering/administrative control options;
- (2) Selection of optimum control methods and completion of design;
- (3) Procurement, installation and operation of selected control measures;
- (4) Testing and acceptance or modification/redesign of controls.

All proposed control measures shall be approved for each particular use by a competent industrial hygienist or other technically qualified person. **30-day progress reports are required during the abatement period.**

Date By Which STEP 2 Must be Abated

08/06/2012

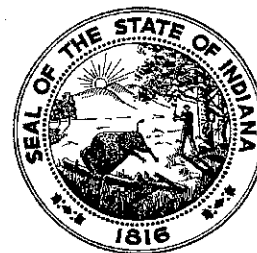
STEP 3- Abatement shall have been completed by the implementation of feasible engineering and/or administrative controls upon verification of their effectiveness in achieving compliance.

Date By Which Violation Must be Abated:

10/17/2012

Proposed Penalty:

\$7,000.00

Indiana Department of LaborIndiana Occupational Safety and Health
Administration**Inspection Number:** 315051318
Inspection Dates: 09/15/2011 -
04/20/2012
Issuance Date: 06/18/2012**Safety Order and Notification of Penalty****Company Name:** Sensient Flavors, LLC
Inspection Site: 5600 West Raymond Street, Indianapolis, IN 46241**Safety Order 1 Item 9 Type of Violation: **Serious****

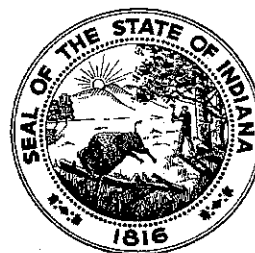
IC 22-8-1.1, Section 2: The employer did not establish and maintain conditions of work which were reasonably safe and healthful for employees, and free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to 2nd and/or 3rd degree burns and smoke inhalation due to improper storage of flammable and combustible liquids:

(a) Parking Lot (5700 Area) - Receiving employees accessed flammable and/or combustible liquids stored inside of six trailers which were located outside of the facility. None of the these six trailers were equipped with ventilation that exhausted the air from inside of the trailers.

(b) Parking Lot (5700 Area) - Receiving employees accessed flammable and/or combustible liquids stored inside of six trailers which were located outside of the facility. None of the these six trailers were equipped with spill containment systems.

Among other methods, one feasible and acceptable method to correct these hazards is to store flammable and combustible liquids in accordance with the National Fire Protection Association's (NFPA) *Flammable and Combustible Liquids Code* (NFPA 30-2008). Specifically, the trailers should be designed in accordance with Section 14 (Hazardous Material Storage Lockers) of NFPA 30-2008.

Date By Which Violation Must be Abated:**07/13/2012****Proposed Penalty:****\$5,000.00**

Indiana Department of LaborIndiana Occupational Safety and Health
Administration**Inspection** 315051318
Number:
Inspection Dates: 09/15/2011 -
04/20/2012
Issuance Date: 06/18/2012**Safety Order and Notification of Penalty****Company Name:** Sensient Flavors, LLC
Inspection Site: 5600 West Raymond Street, Indianapolis, IN 46241**Safety Order 1 Item 10 Type of Violation: **Serious****

29 CFR 1910.36(b)(1): Building(s) or structure(s) designed for human occupancy were not provided with exits sufficient to permit the prompt escape of occupants in case of fire or other emergency:

(a) X-Oil Room - Employees who worked inside of and near the X-Oil Room, a high hazard area, would have to travel an excessive distance to reach the nearest emergency exit(s). The closest three emergency exits to the X-Oil Room were located inside of the Flammable Storage Room 14 (Area 14), the Maintenance Shop and the Reactions Area. The Area 14 Exit was located approximately 213-feet from the furthest point where X-Oil Room employees would access the emergency exit. The Maintenance Shop Exit was located approximately 217-feet from the furthest point where X-Oil Room employees would access the emergency exit. The Reactions Area Exit was located approximately 193-feet from the furthest point where X-Oil Room employees would access the emergency exit.

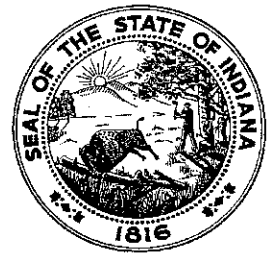
(b) Liquid Compounding Area - Employees who worked inside of and near the Liquid Compounding Area, a high hazard area, would have to travel an excessive distance to reach the nearest emergency exit(s). The closest two emergency exits to the Liquid Compounding Area were located inside of the Receiving Department and near the Old Dock at the North end of the facility. The Receiving Department Exit was located approximately 287-feet from the furthest point where Liquid Compounding Area employees would access the emergency exit. The Old Dock Exit was located approximately 244-feet from the furthest point where Liquid Compounding Area employees would access the emergency exit.

Date By Which Violation Must be Abated:**07/13/2012****Proposed Penalty:****\$5,000.00**

Indiana Department of Labor

Indiana Occupational Safety and Health
Administration

Inspection Number: 315051318
Inspection Dates: 09/15/2011 - 04/20/2012
Issuance Date: 06/18/2012



Safety Order and Notification of Penalty

Company Name: Sensient Flavors, LLC
Inspection Site: 5600 West Raymond Street, Indianapolis, IN 46241

Safety Order 1 Item 11 Type of Violation: Serious

29 CFR 1910.37(a)(2): Exit routes were not arranged so that employees did not have to travel toward a high hazard area:

(a) Flammable Storage Room (Area 14) - One of the designated emergency exit route(s) from the X-Oil Room ran through Area 14, where approximately 11,000 gallons of flammable (Class IA, IB & IC) liquids were stored.

(b) Reactions Area - One of the designated emergency exit route(s) from the X-Oil Room ran through the Reactions Area, where concentrations of hydrogen sulfide (H₂S) in excess of the OSHA Permissible Exposure Limit (PEL) (Ceiling) and IDLH were present.

Date By Which Violation Must be Abated: 07/13/2012
Proposed Penalty: \$5,000.00

Safety Order 1 Item 12 Type of Violation: Serious

29 CFR 1910.106(e)(2)(iv)(d): Flammable or combustible liquids were not drawn from or transferred into vessels, containers, or portable tanks within a building only through a closed piping system, from safety cans, by means of a device drawing through the top, or from a container or portable tanks by gravity through an approved self-closing valve:

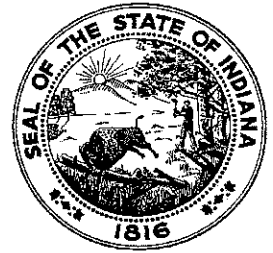
Facility Wide - Employees transferred flammable and combustible liquids such as, but not limited to ethyl alcohol (ethanol), acetic acid, dimethyl sulfide and benzaldehyde from various drums and/or containers using manually activated dispensing valves.

Date By Which Violation Must be Abated: 07/13/2012
Proposed Penalty: \$5,000.00

Indiana Department of Labor

Indiana Occupational Safety and Health
Administration

Inspection Number: 315051318
Inspection Dates: 09/15/2011 - 04/20/2012
Issuance Date: 06/18/2012



Safety Order and Notification of Penalty

Company Name: Sensient Flavors, LLC
Inspection Site: 5600 West Raymond Street, Indianapolis, IN 46241

Safety Order 1 Item 13 Type of Violation: **Serious**

29 CFR 1910.106(e)(6)(i): Adequate precautions against the ignition of flammable vapors were not taken:

X-Oil Room, Liquid Compounding - Compounders transferred flammable liquids such as, but not limited to acetaldehyde (a Class IA Flammable Liquid), diacetyl (a Class IB Flammable Liquid), ethanol (a Class IB Flammable Liquid), propionaldehyde (a Class IB Flammable Liquid) and dimethyl sulfide (a Class IB Flammable Liquid) from one portable container to another portable container without grounding and bonding the containers used during the transfer operations.

Date By Which Violation Must be Abated:

07/13/2012

Proposed Penalty:

\$7,000.00

Safety Order 1 Item 14 Type of Violation: **Serious**

29 CFR 1910.106(e)(6)(ii): Class I flammable liquid(s) were dispensed into containers without electrically interconnecting the nozzle and the container:

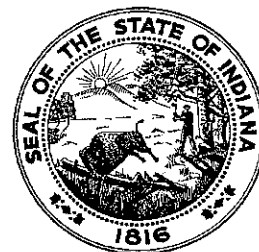
X-Oil Room, Liquid Compounding - Compounders transferred flammable liquids such as, but not limited to acetaldehyde (a Class IA Flammable Liquid), diacetyl (a Class IB Flammable Liquid), ethanol (a Class IB Flammable Liquid), propionaldehyde (a Class IB Flammable Liquid) and dimethyl sulfide (a Class IB Flammable Liquid) from one portable container to another portable container without grounding and bonding the containers used during the transfer operations.

Date By Which Violation Must be Abated:

07/13/2012

Proposed Penalty:

\$7,000.00

Indiana Department of LaborIndiana Occupational Safety and Health
Administration**Inspection Number:** 315051318
Inspection Dates: 09/15/2011 -
04/20/2012
Issuance Date: 06/18/2012**Safety Order and Notification of Penalty****Company Name:** Sensient Flavors, LLC
Inspection Site: 5600 West Raymond Street, Indianapolis, IN 46241**Safety Order 1 Item 15 Type of Violation: **Serious****

29 CFR 1910.134(d)(1)(iii): The employer did not identify and evaluate the respiratory hazard(s) in the workplace with an evaluation which included a reasonable estimate of employee exposures to respiratory hazard(s) and an identification of the contaminant's chemical state and physical form. Where the employer could not identify or reasonably estimate the employee exposure, the employer did not consider the atmosphere to be IDLH:

Reactions Area - An Industrial Scientific Corporation (ISC) iTrans Part Number 77023554 Hydrogen Sulfide (H₂S) Monitor was mounted on the East wall of the Reactions Area. Employees also wore BW Technologies GasAlertClip Extreme Model GA2XT-H H₂S Monitors. The H₂S concentrations measured by the fixed (wall) H₂S monitor and the personal H₂S monitors were not recorded or used to evaluate the respiratory hazards. Even though there was no reasonable estimate of employee exposure to H₂S, the employer did not consider the atmosphere inside of the Reactions Area to be IDLH. Compounders inside of the Reactions Area were exposed to H₂S concentrations up to approximately 10.0 times the OSHA Permissible Exposure Limit (PEL) of 20 parts per million (ppm) (Ceiling) and 2.0 times the NIOSH IDLH of 100 ppm.

Date By Which Violation Must be Abated:**07/13/2012****Proposed Penalty:****\$7,000.00**

Indiana Department of LaborIndiana Occupational Safety and Health
Administration**Inspection** 315051318
Number:
Inspection Dates: 09/15/2011 -
04/20/2012
Issuance Date: 06/18/2012**Safety Order and Notification of Penalty****Company Name:** Sensient Flavors, LLC
Inspection Site: 5600 West Raymond Street, Indianapolis, IN 46241**Safety Order 1 Item 16 Type of Violation: **Serious****

29 CFR 1910.134(d)(2)(i): The employer did not provide a full facepiece pressure demand SCBA certified by NIOSH for a minimum service life of thirty minutes, or a combination full facepiece pressure demand supplied-air respirator (SAR) with auxiliary self-contained air supply for employee use in IDLH atmospheres:

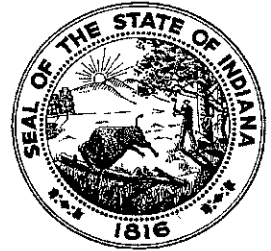
(a) Reactions Area - A Compounder was exposed to hydrogen sulfide at 172 parts per million (ppm); approximately 8.60 times the OSHA Permissible Exposure Limit (PEL) of 20 ppm (Ceiling) and approximately 1.72 times the NIOSH IDLH of 100 ppm. The exposure level was derived at 2:21:16 pm on January 26, 2012. The Compounder who was exposed to this hydrogen sulfide concentration wore a North Full-Face Respirator with North Model 75SC Multi-Gas Respirator Cartridges, and Compounders did not evacuate the Reactions Area when their personal hydrogen sulfide monitor alarmed.

(b) Reactions Area - A Compounder was exposed to hydrogen sulfide at 200 parts per million (ppm); approximately 10.0 times the OSHA Permissible Exposure Limit (PEL) of 20 ppm (Ceiling) and approximately 2.0 times the NIOSH IDLH of 100 ppm. The exposure level was derived at 2:21:21 pm on January 26, 2012. The Compounder who was exposed to this hydrogen sulfide concentration wore a North Full-Face Respirator with North Model 75SC Multi-Gas Respirator Cartridges, and Compounders did not evacuate the Reactions Area when their personal hydrogen sulfide monitor alarmed.

(c) Reactions Area - A Compounder was exposed to hydrogen sulfide at 200 parts per million (ppm); approximately 10.0 times the OSHA Permissible Exposure Limit (PEL) of 20 ppm (Ceiling) and approximately 2.0 times the NIOSH IDLH of 100 ppm. The exposure level was derived at 2:21:26 pm on January 26, 2012. The Compounder who was exposed to this hydrogen sulfide concentration wore a North Full-Face Respirator with North Model 75SC Multi-Gas Respirator Cartridges, and Compounders did not evacuate the Reactions Area when their personal hydrogen sulfide monitor alarmed.

(d) Reactions Area - A Compounder was exposed to hydrogen sulfide at 125 parts per million (ppm); approximately 6.25 times the OSHA Permissible Exposure Limit (PEL) of 20 ppm (Ceiling) and approximately 2.0 times the NIOSH IDLH of 100 ppm. The exposure level was derived at 2:21:31 pm on January 26, 2012. The Compounder who was exposed to this hydrogen sulfide concentration wore a North Full-Face Respirator with North Model 75SC Multi-Gas Respirator Cartridges, and Compounders did not evacuate the Reactions Area when their personal hydrogen sulfide monitor alarmed.

Date By Which Violation Must be Abated:**07/13/2012****Proposed Penalty:****\$7,000.00**

Indiana Department of LaborIndiana Occupational Safety and Health
Administration**Inspection Number:** 315051318
Inspection Dates: 09/15/2011 -
04/20/2012
Issuance Date: 06/18/2012**Safety Order and Notification of Penalty****Company Name:** Sensient Flavors, LLC
Inspection Site: 5600 West Raymond Street, Indianapolis, IN 46241**Safety Order 1 Item 17 Type of Violation: **Serious****

29 CFR 1910.134(d)(3)(i): The employer did not provide a respirator that was adequate to protect the health of the employee and ensure compliance with all other OSHA statutory and regulatory requirements, under routine and reasonably foreseeable emergency situations:

X-Oil Room, Liquid Compounding - Compounders who were exposed to diacetyl (2,3-butanedione) were required to wear full-face air-purifying respirators (APR) with organic vapor cartridges. While wearing these APRs, Compounders were exposed to diacetyl concentrations in excess of approximately 400 times the American Conference of Governmental Industrial Hygienists (ACGIH) 2012 Threshold Limit Value (TLV-STEL) of 0.02 parts per million (ppm) for diacetyl. Based on these exposure levels (concentrations), the Compounders' exposure to diacetyl was above the maximum use concentration (MUC) for the full-face APR.

Date By Which Violation Must be Abated: 07/13/2012
Proposed Penalty: \$7,000.00**Safety Order 1 Item 18 Type of Violation: **Serious****

29 CFR 1910.134(d)(3)(i)(B)(1): The employer did not select a respirator for employee use that maintained the employee's exposure to the hazardous substance, when measured outside the respirator, at or below the maximum use concentration (MUC):

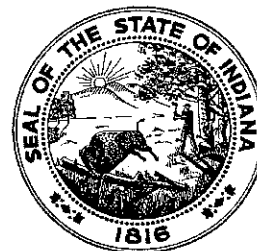
X-Oil Room, Liquid Compounding - Compounders who were exposed to diacetyl (2,3-butanedione) were required to wear full-face air-purifying respirators (APR) equipped with organic vapor cartridges. While wearing these APRs, Compounders were exposed to diacetyl concentrations in excess of approximately 400 times the American Conference of Governmental Industrial Hygienists (ACGIH) 2012 Threshold Limit Value (TLV-STEL) of 0.02 parts per million (ppm) for diacetyl. Based on these exposure levels (concentrations), the Compounders' exposure to diacetyl was above the maximum use concentration (MUC) for the full-face APR.

Date By Which Violation Must be Abated: 07/13/2012
Proposed Penalty: \$7,000.00

Indiana Department of Labor

Indiana Occupational Safety and Health
Administration

Inspection Number: 315051318
Inspection Dates: 09/15/2011 - 04/20/2012
Issuance Date: 06/18/2012



Safety Order and Notification of Penalty

Company Name: Sensient Flavors, LLC
Inspection Site: 5600 West Raymond Street, Indianapolis, IN 46241

Safety Order 1 Item 19 Type of Violation: **Serious**

29 CFR 1910.134(m)(4): Written materials required to be retained under this paragraph were not made available upon request to affected employees and to the Assistant Secretary or designee for examination and copying:

Facility Wide - Upon written request from the Compliance Officers, Sensient Flavors did not produce for examination or copying the written recommendation regarding each employee's ability to wear a respirator.

Date By Which Violation Must be Abated: 07/13/2012
Proposed Penalty: \$5,000.00

Safety Order 1 Item 20 Type of Violation: **Serious**

29 CFR 1910.138(a): The employer did not select and require employees to use appropriate hand protection when employees' hands were exposed to hazards such as those from skin absorption of harmful substances; severe cuts or lacerations; severe abrasions; punctures; chemical burns; thermal burns; and harmful temperature extremes:

Warehouse (Near Dry Blend), Storage Rack Number - 80F09A - An Environmental, Health and Safety (EHS) Engineer handled and removed the lid from a container of 6-Methylcoumarin (K01552) without wearing chemical resistant gloves. The container contained 6-Methylcoumarin powder, which potentially causes skin irritation and skin lesions and could be potentially absorbed through the skin.

Date By Which Violation Must be Abated: 07/13/2012
Proposed Penalty: \$2,500.00

Indiana Department of LaborIndiana Occupational Safety and Health
Administration**Inspection** 315051318
Number:
Inspection Dates: 09/15/2011 -
04/20/2012
Issuance Date: 06/18/2012**Safety Order and Notification of Penalty****Company Name:** Sensient Flavors, LLC
Inspection Site: 5600 West Raymond Street, Indianapolis, IN 46241**Safety Order 1 Item 21 Type of Violation: **Serious****

29 CFR 1910.146(d)(9): Under the permit-required confined space program required by 29 CFR 1910.146(c)(4), the employer did not develop and implement procedures for summoning rescue and emergency services, for rescuing entrants from permit spaces to rescued employees, and for preventing unauthorized personnel from attempting a rescue:

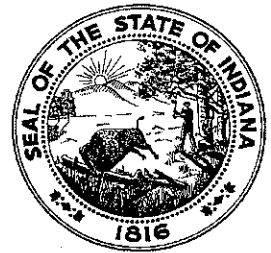
Liquid Compounding and Flammable Liquid Compounding Areas - Maintenance employees entered permit-required confined spaces (PRCSs) such as, but not limited to process vessels and tanks. Sensient Flavors' confined space entry rescue service was the Wayne Township Fire Department (WTFD), who was to be contacted through "911". However, the WTFD was not equipped, trained or proficient in performing confined space entry rescues. In fact, the WTFD does not have a confined space entry rescue team.

Date By Which Violation Must be Abated:**07/13/2012****Proposed Penalty:****\$5,000.00****Safety Order 1 Item 22 Type of Violation: **Serious****

29 CFR 1910.146(k)(1)(i): The employer did not evaluate the prospective rescuer's ability to respond to a rescue summons in a timely manner, considering the hazards identified:

Liquid Compounding and Flammable Liquid Compounding Areas - Maintenance employees entered permit-required confined spaces (PRCSs) such as, but not limited to process vessels and tanks. Sensient Flavors' confined space entry rescue service was the Wayne Township Fire Department (WTFD), who was to be contacted through "911". However, the WTFD was not equipped, trained or proficient in performing confined space entry rescues. In fact, the WTFD does not have a confined space entry rescue team.

Date By Which Violation Must be Abated:**07/13/2012****Proposed Penalty:****\$5,000.00**

Indiana Department of LaborIndiana Occupational Safety and Health
Administration**Inspection** 315051318
Number:
Inspection Dates: 09/15/2011 -
04/20/2012
Issuance Date: 06/18/2012**Safety Order and Notification of Penalty****Company Name:** Sensient Flavors, LLC
Inspection Site: 5600 West Raymond Street, Indianapolis, IN 46241**Safety Order 1 Item 23** Type of Violation: **Serious**

29 CFR 1910.146(k)(1)(ii): The employer did not evaluate a prospective rescue service's ability, in terms of proficiency with rescue-related tasks and equipment, to function appropriately while rescuing entrants from the particular permit space or types of permit spaces identified:

Liquid Compounding and Flammable Liquid Compounding Areas - Maintenance employees entered permit-required confined spaces (PRCSs) such as, but not limited to process vessels and tanks. Sensient Flavors' confined space entry rescue service was the Wayne Township Fire Department (WTFD), who was to be contacted through "911". However, the WTFD was not equipped, trained or proficient in performing confined space entry rescues. In fact, the WTFD does not have a confined space entry rescue team.

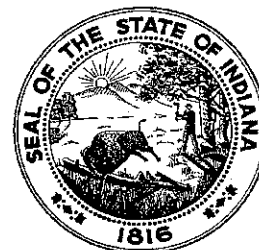
Date By Which Violation Must be Abated: 07/13/2012
Proposed Penalty: \$5,000.00

Safety Order 1 Item 24 Type of Violation: **Serious**

29 CFR 1910.146(k)(1)(iv): The employer did not inform each rescue team or service of the hazards they may confront when called on to perform rescue at the site:

Liquid Compounding and Flammable Liquid Compounding Areas - Maintenance employees entered permit-required confined spaces (PRCSs) such as, but not limited to process vessels and tanks. Sensient Flavors' confined space entry rescue service was the Wayne Township Fire Department (WTFD), who was to be contacted through "911". However, the WTFD was not equipped, trained or proficient in performing confined space entry rescues. In fact, the WTFD does not have a confined space entry rescue team.

Date By Which Violation Must be Abated: 07/13/2012
Proposed Penalty: \$5,000.00

Indiana Department of LaborIndiana Occupational Safety and Health
Administration**Inspection** 315051318
Number:
Inspection Dates: 09/15/2011 -
04/20/2012
Issuance Date: 06/18/2012**Safety Order and Notification of Penalty****Company Name:** Sensient Flavors, LLC
Inspection Site: 5600 West Raymond Street, Indianapolis, IN 46241**Safety Order 1 Item 25 Type of Violation: **Serious****

29 CFR 1910.146(k)(5)(v): The employer did not provide the rescue team or service selected with access to all permit spaces from which rescue may have been necessary so that the rescue service could develop appropriate rescue plans and practice rescue operations:

Liquid Compounding and Flammable Liquid Compounding Areas - Maintenance employees entered permit-required confined spaces (PRCSs) such as, but not limited to process vessels and tanks. Sensient Flavors' confined space entry rescue service was the Wayne Township Fire Department (WTFD), who was to be contacted through "911". However, the WTFD was not equipped, trained or proficient in performing confined space entry rescues. In fact, the WTFD does not have a confined space entry rescue team.

Date By Which Violation Must be Abated:**07/13/2012****Proposed Penalty:****\$5,000.00****Safety Order 1 Item 26 Type of Violation: **Serious****

29 CFR 1910.307(c): Equipment, wiring methods, and installations of equipment in hazardous (classified) locations were not intrinsically safe, or approved for the hazardous (classified) location, or safe for the hazardous (classified) location:

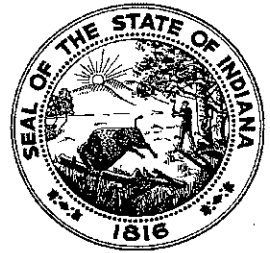
Parking Lot (5700 Area) - Receiving employees accessed flammable and/or combustible liquids stored inside of six trailers which were located outside of the facility. Electrical equipment and installations such as, but not limited to the Thermo King Model 210-30 Air Return Bulkhead used on these six trailers were not listed or approved for use in a Class I, Division 2 hazardous location.

Date By Which Violation Must be Abated:**07/13/2012****Proposed Penalty:****\$5,000.00**

Indiana Department of Labor

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Safety Order and Notification of Penalty

Company Name: Sensient Flavors, LLC
Inspection Site: 5600 West Raymond Street, Indianapolis, IN 46241

Safety Order 1 Item 27 Type of Violation: **Serious**

29 CFR 1910.1200(h)(1): The employer did not provide employees with effective information and training on hazardous chemicals in their work area at the time of their initial assignment, and whenever a new physical or health hazard the employees had not been previously trained about was introduced to their work area:

Facility Wide - Employees were not provided effective training on the physical and health hazards associated with hazardous chemicals such as, but not limited to diacetyl (2-3-butanedione) and hydrogen sulfide (H₂S).

Date By Which Violation Must be Abated:

07/13/2012

Proposed Penalty:

\$7,000.00

Indiana Department of Labor

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Safety Order and Notification of Penalty

Company Name: Sensient Flavors, LLC
Inspection Site: 5600 West Raymond Street, Indianapolis, IN 46241

Safety Order 2 Item 1 Type of Violation: **Knowing**

IC 22-8-1.1, Section 2: The employer did not establish and maintain conditions of work which were reasonably safe and healthful for employees, and free from recognized hazards that were causing or likely to cause death or serious physical harm to employees in that employees were exposed to harmful airborne concentrations of diacetyl (2,3-butanedione) which could lead to employees experiencing injuries and/or illnesses such as, but not limited to permanent lung impairment and/or disease:

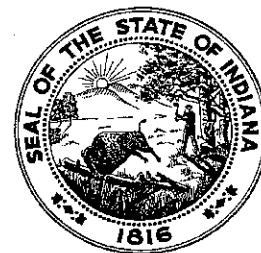
(a) X-Oil Room, Liquid Compounding - A Compounder was exposed to diacetyl (2,3-butanedione) at 3.18 parts per million (ppm) for a 15-minute time-weighted average (TWA); approximately 159 times the 2012 American Conference of Governmental Industrial Hygienists (ACGIH) Threshold Limit Value (TLV-STEL) of 0.02 ppm for diacetyl and approximately 169 times the limit of quantification (LOQ). The exposure level was derived from a 9 minute sampling period on December 19, 2011. Zero exposure was assumed for the 6 minutes not sampled.

(b) X-Oil Room, Liquid Compounding - A Compounder was exposed to diacetyl (2,3-butanedione) at 0.0994 parts per million (ppm) for an 8-hour time-weighted average (TWA); approximately 9.94 times the 2012 ACGIH Threshold Limit Value (TLV-TWA) of 0.01 ppm for diacetyl and approximately 169 times the limit of quantification (LOQ). The exposure level was derived from a 9 minute sampling period on December 19, 2011. Zero exposure was assumed for the 471 minutes not sampled.

(c) X-Oil Room, Liquid Compounding - A Compounder was exposed to diacetyl (2,3-butanedione) at 1.32 parts per million (ppm) for a 15-minute time-weighted average (TWA); approximately 66 times the 2012 ACGIH Threshold Limit Value (TLV-STEL) of 0.02 ppm for diacetyl and approximately 72 times the limit of quantification (LOQ). The exposure level was derived from a 9 minute sampling period on December 19, 2011. Zero exposure was assumed for the 6 minutes not sampled.

(d) X-Oil Room, Liquid Compounding - A Compounder was exposed to diacetyl (2,3-butanedione) at 0.0413 parts per million (ppm) for an 8-hour time-weighted average (TWA); approximately 4.13 times the 2012 ACGIH Threshold Limit Value (TLV-TWA) of 0.01 ppm for diacetyl and approximately 169 times the limit of quantification (LOQ). The exposure level was derived from a 9 minute sampling period on December 19, 2011. Zero exposure was assumed for the 471 minutes not sampled.

(e) X-Oil Room, Liquid Compounding - A Compounder was exposed to diacetyl (2,3-butanedione) at 6.10 parts per

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Inspection Site: 5600 West Raymond Street, Indianapolis, IN 46241

million (ppm) for a 15-minute time-weighted average (TWA); approximately 305 times the 2012 ACGIH Threshold Limit Value (TLV-STEL) of 0.02 ppm for diacetyl and approximately 328 times the limit of quantification (LOQ). The exposure level was derived from a 15 minute sampling period on December 21, 2011.

(f) X-Oil Room, Liquid Compounding - A Compounder was exposed to diacetyl (2,3-butanedione) at 3.23 parts per million (ppm) for a 15-minute time-weighted average (TWA); approximately 162 times the 2012 ACGIH Threshold Limit Value (TLV-STEL) of 0.02 ppm for diacetyl and approximately 174 times the limit of quantification (LOQ). The exposure level was derived from a 10 minute sampling period on December 21, 2011. Zero exposure was assumed for the 5 minutes not sampled.

(g) X-Oil Room, Liquid Compounding - A Compounder was exposed to diacetyl (2,3-butanedione) at 0.2917 parts per million (ppm) for an 8-hour time-weighted average (TWA); approximately 29 times the 2012 ACGIH Threshold Limit Value (TLV-TWA) of 0.01 ppm for diacetyl and an average of approximately 251 times the limit of quantification (LOQ). The exposure level was derived from a 25 minute sampling period on December 21, 2011. Zero exposure was assumed for the 455 minutes not sampled.

(h) X-Oil Room, Liquid Compounding - A Compounder was exposed to diacetyl (2,3-butanedione) at 6.13 parts per million (ppm) for a 15-minute time-weighted average (TWA); approximately 307 times the 2012 ACGIH Threshold Limit Value (TLV-STEL) of 0.02 ppm for diacetyl and approximately 335 times the limit of quantification (LOQ). The exposure level was derived from a 14 minute sampling period on December 21, 2011. Zero exposure was assumed for the 1 minute not sampled.

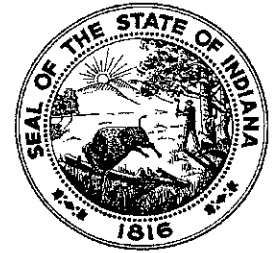
(i) X-Oil Room, Liquid Compounding - A Compounder was exposed to diacetyl (2,3-butanedione) at 1.57 parts per million (ppm) for a 15-minute time-weighted average (TWA); approximately 79 times the 2012 ACGIH Threshold Limit Value (TLV-STEL) of 0.02 ppm for diacetyl and approximately 86 times the limit of quantification (LOQ). The exposure level was derived from a 11 minute sampling period on December 21, 2011. Zero exposure was assumed for the 4 minutes not sampled.

(j) X-Oil Room, Liquid Compounding - A Compounder was exposed to diacetyl (2,3-butanedione) at 0.2407 parts per million (ppm) for an 8-hour time-weighted average (TWA); approximately 24 times the 2012 ACGIH Threshold Limit Value (TLV-TWA) of 0.01 ppm for diacetyl and an average of approximately 210 times the limit of quantification (LOQ). The exposure level was derived from a 25 minute sampling period on December 21, 2011. Zero exposure was assumed for the 455 minutes not sampled.

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Company Name: Sensient Flavors, LLC
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(k) Packaging Department - A Packager was exposed to diacetyl (2,3-butanedione) at 0.0134 parts per million (ppm) for an 8-hour time-weighted average (TWA); approximately 1.34 times the 2012 ACGIH Threshold Limit Value (TLV-TWA) of 0.01 ppm for diacetyl and approximately 8.85 times the limit of quantification (LOQ). The exposure level was derived from a 92 minute sampling period on January 18, 2011. Zero exposure was assumed for the 388 minutes not sampled.

(l) Packaging Department - A Packager was exposed to diacetyl (2,3-butanedione) at 0.05 parts per million (ppm) for a 15-minute time-weighted average (TWA); approximately 2.58 times the 2012 ACGIH Threshold Limit Value (TLV-STEL) of 0.02 ppm for diacetyl and approximately 2.8 times the limit of quantification (LOQ). The exposure level was derived from a 13 minute sampling period on January 18, 2011. Zero exposure was assumed for the 2 minutes not sampled.

(m) X-Oil Room, Liquid Compounding - A Compounder was exposed to diacetyl (2,3-butanedione) at 0.9013 parts per million (ppm) for a 15-minute time-weighted average (TWA); approximately 45 times the 2012 ACGIH Threshold Limit Value (TLV-STEL) of 0.02 ppm for diacetyl and approximately 48 times the limit of quantification (LOQ). The exposure level was derived from a 13 minute sampling period on February 10, 2012. Zero exposure was assumed for the 2 minutes not sampled.

(n) X-Oil Room, Liquid Compounding - A Compounder was exposed to diacetyl (2,3-butanedione) at 0.2370 parts per million (ppm) for a 15-minute time-weighted average (TWA); approximately 12 times the 2012 ACGIH Threshold Limit Value (TLV-STEL) of 0.02 ppm for diacetyl and approximately 13 times the limit of quantification (LOQ). The exposure level was derived from a 15 minute sampling period on February 10, 2012.

(o) X-Oil Room, Liquid Compounding - A Compounder was exposed to diacetyl (2,3-butanedione) at 5.28 parts per million (ppm) for a 15-minute time-weighted average (TWA); approximately 264 times the 2012 ACGIH Threshold Limit Value (TLV-STEL) of 0.02 ppm for diacetyl and approximately 279 times the limit of quantification (LOQ). The exposure level was derived from a 14 minute sampling period on February 10, 2012. Zero exposure was assumed for the 1 minute not sampled.

(p) X-Oil Room, Liquid Compounding - A Compounder was exposed to diacetyl (2,3-butanedione) at 8.40 parts per million (ppm) for a 15-minute time-weighted average (TWA); approximately 420 times the 2012 ACGIH Threshold Limit Value (TLV-STEL) of 0.02 ppm for diacetyl and approximately 445 times the limit of quantification (LOQ). The exposure level was derived from a 12 minute sampling period on February 10, 2012. Zero exposure was assumed for the 3 minutes not sampled.

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(q) X-Oil Room, Liquid Compounding - A Compounder was exposed to diacetyl (2,3-butanedione) at 0.4632 parts per million (ppm) for an 8-hour time-weighted average (TWA); approximately 46 times the 2012 ACGIH Threshold Limit Value (TLV-TWA) of 0.01 ppm for diacetyl and an average of approximately 196 times the limit of quantification (LOQ). The exposure level was derived from a 54 minute sampling period on February 10, 2012. Zero exposure was assumed for the 426 minutes not sampled.

(r) X-Oil Room, Liquid Compounding - A Compounder was exposed to diacetyl (2,3-butanedione) at 2.70 parts per million (ppm) for a 15-minute time-weighted average (TWA); approximately 135 times the 2012 ACGIH Threshold Limit Value (TLV-STEL) of 0.02 ppm for diacetyl and approximately 144 times the limit of quantification (LOQ). The exposure level was derived from a 12 minute sampling period on February 10, 2012. Zero exposure was assumed for the 3 minutes not sampled.

(s) X-Oil Room, Liquid Compounding - A Compounder was exposed to diacetyl (2,3-butanedione) at 0.0339 parts per million (ppm) for a 15-minute time-weighted average (TWA); approximately 1.70 times the 2012 ACGIH Threshold Limit Value (TLV-STEL) of 0.02 ppm for diacetyl and approximately 1.80 times the limit of quantification (LOQ). The exposure level was derived from a 15 minute sampling period on February 10, 2012.

(t) X-Oil Room, Liquid Compounding - A Compounder was exposed to diacetyl (2,3-butanedione) at 4.79 parts per million (ppm) for a 15-minute time-weighted average (TWA); approximately 240 times the 2012 ACGIH Threshold Limit Value (TLV-STEL) of 0.02 ppm for diacetyl and approximately 254 times the limit of quantification (LOQ). The exposure level was derived from a 15 minute sampling period on February 10, 2012.

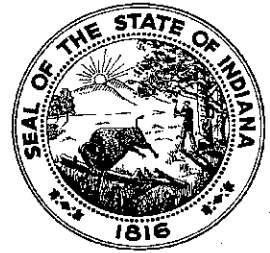
(u) X-Oil Room, Liquid Compounding - A Compounder was exposed to diacetyl (2,3-butanedione) at 9.19 parts per million (ppm) for a 15-minute time-weighted average (TWA); approximately 459 times the 2012 ACGIH Threshold Limit Value (TLV-STEL) of 0.02 ppm for diacetyl and approximately 486 times the limit of quantification (LOQ). The exposure level was derived from a 13 minute sampling period on February 10, 2012. Zero exposure was assumed for the 2 minutes not sampled.

(v) X-Oil Room, Liquid Compounding - A Compounder was exposed to diacetyl (2,3-butanedione) at 0.5223 parts per million (ppm) for an 8-hour time-weighted average (TWA); approximately 52 times the 2012 ACGIH Threshold Limit Value (TLV-TWA) of 0.01 ppm for diacetyl and an average of approximately 221 times the limit of quantification (LOQ). The exposure level was derived from a 55 minute sampling period on February 10, 2012. Zero exposure was assumed for the 425 minutes not sampled.

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(w) X-Oil Room, Liquid Compounding - A Compounder was exposed to diacetyl (2,3-butanedione) at 0.050 parts per million (ppm) for a 15-minute time-weighted average (TWA); approximately 2.28 times the 2012 ACGIH Threshold Limit Value (TLV-STEL) of 0.02 ppm for diacetyl and approximately 2.42 times the limit of quantification (LOQ). The exposure level was derived from a 11 minute sampling period on February 13, 2012. Zero exposure was assumed for the 4 minutes not sampled.

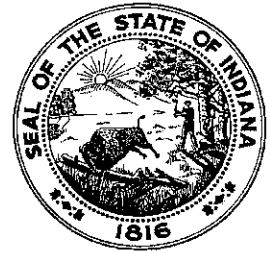
(x) X-Oil Room, Liquid Compounding - A Compounder was exposed to diacetyl (2,3-butanedione) at 0.324 parts per million (ppm) for a 15-minute time-weighted average (TWA); approximately 16 times the 2012 ACGIH Threshold Limit Value (TLV-STEL) of 0.02 ppm for diacetyl and approximately 17 times the limit of quantification (LOQ). The exposure level was derived from a 15 minute sampling period on February 13, 2012.

(y) X-Oil Room, Liquid Compounding - A Compounder was exposed to diacetyl (2,3-butanedione) at 0.0115 parts per million (ppm) for an 8-hour time-weighted average (TWA); approximately 1.15 times the 2012 ACGIH Threshold Limit Value (TLV-TWA) of 0.01 ppm for diacetyl and an average of approximately 9.78 times the limit of quantification (LOQ). The exposure level was derived from a 26 minute sampling period on February 13, 2012. Zero exposure was assumed for the 454 minutes not sampled.

(z) X-Oil Room, Liquid Compounding - A Compounder was exposed to diacetyl (2,3-butanedione) at 0.0764 parts per million (ppm) for a 15-minute time-weighted average (TWA); approximately 3.82 times the 2012 ACGIH Threshold Limit Value (TLV-STEL) of 0.02 ppm for diacetyl and approximately 4.05 times the limit of quantification (LOQ). The exposure level was derived from a 12 minute sampling period on February 13, 2012. Zero exposure was assumed for the 3 minutes not sampled.

(aa) X-Oil Room, Liquid Compounding - A Compounder was exposed to diacetyl (2,3-butanedione) at 0.493 parts per million (ppm) for a 15-minute time-weighted average (TWA); approximately 25 times the 2012 ACGIH Threshold Limit Value (TLV-STEL) of 0.02 ppm for diacetyl and approximately 26 times the limit of quantification (LOQ). The exposure level was derived from a 15 minute sampling period on February 13, 2012.

(bb) X-Oil Room, Liquid Compounding - A Compounder was exposed to diacetyl (2,3-butanedione) at 0.0178 parts per million (ppm) for an 8-hour time-weighted average (TWA); approximately 1.78 times the 2012 ACGIH Threshold Limit Value (TLV-TWA) of 0.01 ppm for diacetyl and an average of approximately 15 times the limit of quantification (LOQ). The exposure level was derived from a 27 minute sampling period on February 13, 2012. Zero exposure was assumed for the 453 minutes not sampled.

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Among other methods, one feasible and acceptable method to correct this hazard is to install a local exhaust ventilation (LEV) system in the portions of the X-Oil Room and Packaging Department where diacetyl (2,3-butanedione) is transferred. This LEV system should be sufficient in power (capture velocity, flowrate, etc.) and location so that any diacetyl (2,3-butanedione) that is generated and/or emitted during transfer/pouring operations is removed from the point of use or generation prior to entering employees' breathing zones.

Abatement Schedule

STEP 1- Effective respiratory protection shall be provided to and used by exposed employees as an interim measure until feasible engineering and/or administrative controls can be implemented or whenever such controls fail to reduce employee exposure to within permissible exposure limits.

Date By Which STEP 1 Must be Abated

07/06/2012

STEP 2- A written detailed plan of abatement shall be submitted to the Director outlining a schedule for the implementation of engineering and/or administrative measures to control employee exposures to noise as referenced in this Safety Order. This plan shall include, at a minimum, target dates for the following actions which must be consistent with the abatement dates required by this Safety Order:

- (1) Evaluation of engineering/administrative control options;
- (2) Selection of optimum control methods and completion of design;
- (3) Procurement, installation and operation of selected control measures;
- (4) Testing and acceptance or modification/redesign of controls.

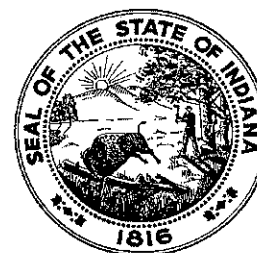
All proposed control measures shall be approved for each particular use by a competent industrial hygienist or other technically qualified person. **30-day progress reports are required during the abatement period.**

Date By Which STEP 2 Must be Abated

08/06/2012

STEP 3- Abatement shall have been completed by the implementation of feasible engineering and/or administrative controls upon verification of their effectiveness in achieving compliance.

Date By Which Violation Must be Abated:**09/17/2012****Proposed Penalty:****\$70,000.00**

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Inspection Site: 5600 West Raymond Street, Indianapolis, IN. 46241**Safety Order 2 Item 2 Type of Violation: **Knowing****

29 CFR 1910.134(d)(1)(i): The employer did not select and provide an appropriate respirator based on the respiratory hazard(s) to which the worker was exposed and workplace and user factors that affected respirator performance and reliability:

(a) Reactions Area - On January 18, 2012, Compounders who were exposed to hydrogen sulfide (H₂S) wore North Model P/80802 Full-Face Respirators equipped with North Part Number N7500-4 AM/MA (ammonia/methylamine) Respirator Cartridges. While pouring ammonium sulfide into a reactor, one of the Compounder's personal H₂S meters alarmed.

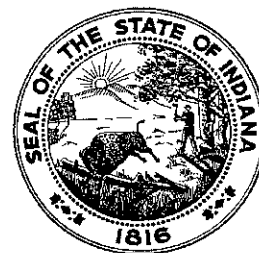
(b) X-Oil Room, Liquid Compounding - Compounders who were exposed to diacetyl (2-3-butanedione) wore 3M full-face air-purifying respirators with 3M Part Number 6003 Organic Vapor/Acid Gas Respirator Cartridges which were not equipped with particulate filters. While wearing these APRs, Compounders were exposed to diacetyl concentrations in excess of approximately 400 times the American Conference of Governmental Industrial Hygienists (ACGIH) 2012 Threshold Limit Value (TLV-STEL) of 0.02 parts per million (ppm) for diacetyl.

Date By Which Violation Must be Abated:	07/13/2012
Proposed Penalty:	\$70,000.00

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The alleged violations below have been grouped because they involve similar or related hazards that may increase the potential for illness or injury resulting from an accident.

Safety Order 2 Item 3a Type of Violation: **Knowing**

29 CFR 1910.1000(b)(2): Employees were exposed to airborne concentrations of hydrogen sulfide, listed in Table Z-2, in excess of twenty parts per million of hydrogen sulfide (20 ppm) as an acceptable Ceiling concentration:

(a) Reactions Area - A Compounder was exposed to hydrogen sulfide at 25 parts per million (ppm); approximately 1.25 times the OSHA Permissible Exposure Limit (PEL) of 20 ppm (Ceiling). The exposure level was derived at 12:59:50 pm on January 25, 2012.

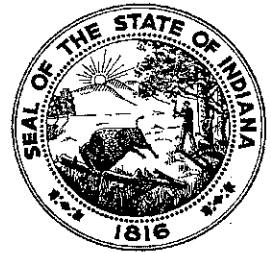
(b) Reactions Area - A Compounder was exposed to hydrogen sulfide at 24 parts per million (ppm); approximately 1.20 times the OSHA Permissible Exposure Limit (PEL) of 20 ppm (Ceiling). The exposure level was derived at 12:59:55 pm on January 25, 2012.

(c) Reactions Area - A Compounder was exposed to hydrogen sulfide at 31 parts per million (ppm); approximately 1.55 times the OSHA Permissible Exposure Limit (PEL) of 20 ppm (Ceiling). The exposure level was derived at 2:15:06 pm on January 26, 2012.

(d) Reactions Area - A Compounder was exposed to hydrogen sulfide at 38 parts per million (ppm); approximately 1.90 times the OSHA Permissible Exposure Limit (PEL) of 20 ppm (Ceiling). The exposure level was derived at 2:15:11 pm on January 26, 2012.

(e) Reactions Area - A Compounder was exposed to hydrogen sulfide at 35 parts per million (ppm); approximately 1.75 times the OSHA Permissible Exposure Limit (PEL) of 20 ppm (Ceiling). The exposure level was derived at 2:15:16 pm on January 26, 2012.

(f) Reactions Area - A Compounder was exposed to hydrogen sulfide at 172 parts per million (ppm); approximately 8.60 times the OSHA Permissible Exposure Limit (PEL) of 20 ppm (Ceiling). The exposure level was derived at 2:21:16 pm on January 26, 2012.

Indiana Department of LaborIndiana Occupational Safety and Health
Administration**Inspection** 315051318
Number:
Inspection Dates: 09/15/2011 -
04/20/2012
Issuance Date: 06/18/2012**Safety Order and Notification of Penalty****Company Name:** Sensient Flavors, LLC
Inspection Site: 5600 West Raymond Street, Indianapolis, IN 46241

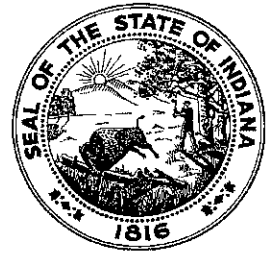
- (g) Reactions Area - A Compounder was exposed to hydrogen sulfide at 200 parts per million (ppm); approximately 10.0 times the OSHA Permissible Exposure Limit (PEL) of 20 ppm (Ceiling). The exposure level was derived at 2:21:21 pm on January 26, 2012.
- (h) Reactions Area - A Compounder was exposed to hydrogen sulfide at 200 parts per million (ppm); approximately 10.0 times the OSHA Permissible Exposure Limit (PEL) of 20 ppm (Ceiling). The exposure level was derived at 2:21:26 pm on January 26, 2012.
- (i) Reactions Area - A Compounder was exposed to hydrogen sulfide at 125 parts per million (ppm); approximately 6.25 times the OSHA Permissible Exposure Limit (PEL) of 20 ppm (Ceiling). The exposure level was derived at 2:21:31 pm on January 26, 2012.
- (j) Reactions Area - A Compounder was exposed to hydrogen sulfide at 66 parts per million (ppm); approximately 3.30 times the OSHA Permissible Exposure Limit (PEL) of 20 ppm (Ceiling). The exposure level was derived at 2:21:36 pm on January 26, 2012.
- (k) Reactions Area - A Compounder was exposed to hydrogen sulfide at 44 parts per million (ppm); approximately 2.20 times the OSHA Permissible Exposure Limit (PEL) of 20 ppm (Ceiling). The exposure level was derived at 2:21:41 pm on January 26, 2012.
- (l) Reactions Area - A Compounder was exposed to hydrogen sulfide at 36 parts per million (ppm); approximately 1.80 times the OSHA Permissible Exposure Limit (PEL) of 20 ppm (Ceiling). The exposure level was derived at 2:21:46 pm on January 26, 2012.
- (m) Reactions Area - A Compounder was exposed to hydrogen sulfide at 26 parts per million (ppm); approximately 1.30 times the OSHA Permissible Exposure Limit (PEL) of 20 ppm (Ceiling). The exposure level was derived at 2:21:51 pm on January 26, 2012.

Date By Which Violation Must be Abated:**09/17/2012****Proposed Penalty:****\$70,000.00**

Indiana Department of Labor

Indiana Occupational Safety and Health
Administration

Inspection Number: 315051318
Inspection Dates: 09/15/2011 - 04/20/2012
Issuance Date: 06/18/2012



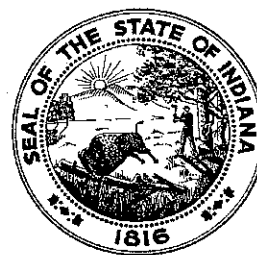
Safety Order and Notification of Penalty

Company Name: Sensient Flavors, LLC
Inspection Site: 5600 West Raymond Street, Indianapolis, IN 46241

Safety Order 2 Item 3b Type of Violation: **Knowing**

29 CFR 1910.1000(e): To achieve compliance with paragraphs (a) through (d) of this section, administrative or engineering controls were not determined and implemented whenever feasible:

- (a) Reactions Area - A Compounder was exposed to hydrogen sulfide at 25 parts per million (ppm); approximately 1.25 times the OSHA Permissible Exposure Limit (PEL) of 20 ppm (Ceiling). The exposure level was derived at 12:59:50 pm on January 25, 2012.
- (b) Reactions Area - A Compounder was exposed to hydrogen sulfide at 24 parts per million (ppm); approximately 1.20 times the OSHA Permissible Exposure Limit (PEL) of 20 ppm (Ceiling). The exposure level was derived at 12:59:55 pm on January 25, 2012.
- (c) Reactions Area - A Compounder was exposed to hydrogen sulfide at 31 parts per million (ppm); approximately 1.55 times the OSHA Permissible Exposure Limit (PEL) of 20 ppm (Ceiling). The exposure level was derived at 2:15:06 pm on January 26, 2012.
- (d) Reactions Area - A Compounder was exposed to hydrogen sulfide at 38 parts per million (ppm); approximately 1.90 times the OSHA Permissible Exposure Limit (PEL) of 20 ppm (Ceiling). The exposure level was derived at 2:15:11 pm on January 26, 2012.
- (e) Reactions Area - A Compounder was exposed to hydrogen sulfide at 35 parts per million (ppm); approximately 1.75 times the OSHA Permissible Exposure Limit (PEL) of 20 ppm (Ceiling). The exposure level was derived at 2:15:16 pm on January 26, 2012.
- (f) Reactions Area - A Compounder was exposed to hydrogen sulfide at 172 parts per million (ppm); approximately 8.60 times the OSHA Permissible Exposure Limit (PEL) of 20 ppm (Ceiling). The exposure level was derived at 2:21:16 pm on January 26, 2012.

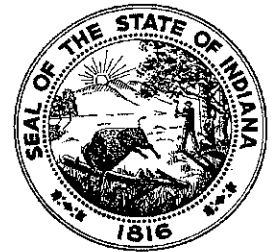
Indiana Department of LaborIndiana Occupational Safety and Health
Administration**Inspection** 315051318
Number:
Inspection Dates: 09/15/2011 -
04/20/2012
Issuance Date: 06/18/2012**Safety Order and Notification of Penalty****Company Name:** Sensient Flavors, LLC
Inspection Site: 5600 West Raymond Street, Indianapolis, IN 46241

- (g) Reactions Area - A Compounder was exposed to hydrogen sulfide at 200 parts per million (ppm); approximately 10.0 times the OSHA Permissible Exposure Limit (PEL) of 20 ppm (Ceiling). The exposure level was derived at 2:21:21 pm on January 26, 2012.
- (h) Reactions Area - A Compounder was exposed to hydrogen sulfide at 200 parts per million (ppm); approximately 10.0 times the OSHA Permissible Exposure Limit (PEL) of 20 ppm (Ceiling). The exposure level was derived at 2:21:26 pm on January 26, 2012.
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- (j) Reactions Area - A Compounder was exposed to hydrogen sulfide at 66 parts per million (ppm); approximately 3.30 times the OSHA Permissible Exposure Limit (PEL) of 20 ppm (Ceiling). The exposure level was derived at 2:21:36 pm on January 26, 2012.
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Indiana Department of Labor

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Inspection Number: 315051318
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Safety Order and Notification of Penalty

Company Name: Sensient Flavors, LLC
Inspection Site: 5600 West Raymond Street, Indianapolis, IN 46241

Abatement Schedule

STEP 1- Effective respiratory protection shall be provided to and used by exposed employees as an interim measure until feasible engineering and/or administrative controls can be implemented or whenever such controls fail to reduce employee exposure to within permissible exposure limits.

Date By Which STEP 1 Must be Abated 07/06/2012

STEP 2- A written detailed plan of abatement shall be submitted to the Director outlining a schedule for the implementation of engineering and/or administrative measures to control employee exposures to noise as referenced in this Safety Order. This plan shall include, at a minimum, target dates for the following actions which must be consistent with the abatement dates required by this Safety Order:

- (1) Evaluation of engineering/administrative control options;
- (2) Selection of optimum control methods and completion of design;
- (3) Procurement, installation and operation of selected control measures;
- (4) Testing and acceptance or modification/redesign of controls.

All proposed control measures shall be approved for each particular use by a competent industrial hygienist or other technically qualified person. **30-day progress reports are required during the abatement period.**

Date By Which STEP 2 Must be Abated 08/06/2012

STEP 3- Abatement shall have been completed by the implementation of feasible engineering and/or administrative controls upon verification of their effectiveness in achieving compliance.

Date By Which Violation Must be Abated: 10/17/2012



Jeffrey S. Carter
Deputy Commissioner, IOSHA

Indiana Department of Labor

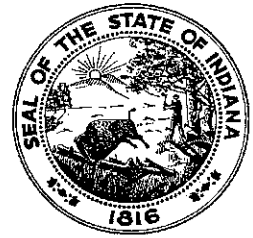
Indiana Occupational Safety and Health Administration

402 West Washington Street

Room W195

Indianapolis, IN 46204-2751

Phone: 317/232-1979 Fax: 317/233-8509



INVOICE/DEBT COLLECTION NOTICE

Company Name: Sensient Flavors, LLC
Inspection Site: 5600 West Raymond Street, Indianapolis, IN 46241
Issuance Date: 06/18/2012

Summary of Penalties for Inspection Number	315051318
Safety Order 01, Serious	= \$113,500.00
Safety Order 02, Knowing	= \$210,000.00
Total Proposed Penalties	\$323,500.00

Penalties are due within fifteen (15) working days of receipt of this notification unless contested. Make your check or money order payable to: "Indiana DOL/IOSHA". Please indicate IOSHA's Inspection Number (indicated above) on the remittance.

IOSHA does not agree to any restrictions or conditions or endorsements put on any check or money order for less than full amount due, and will cash the check or money order as if these restrictions, conditions, or endorsements do not exist.

Corrective action, taken by you for each alleged violation should be submitted to this office on or about the abatement dates indicated on the Safety Order and Notification of Penalty.

A work sheet has been provided to assist in providing the required abatement information. A completed copy of this work sheet should be posted at the worksite with the safety order(s).


Jeffrey S. Carter
Deputy Commissioner, IOSHA


Date